

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66233

February 8, 2011 8:43:24 AM



Page 2

Item ID:	D2332-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Prop Assembly 6.69" long					
Start Date:	2/08/11	Start Qty:	4.00	Cust Item ID:		
Required Date:	2/22/11	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Small Fab	0.00							
Small Fab	Memo	0.00							
	1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459 (drill one per ass'y)								
	2- Ensure no foreign objects inside tube								
	3- Deburr								
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
140 	Large Fab	0.00							
Large Fab	Memo	0.00							
	Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)								
	*****ensure nothing is inside of tube before welding*****								
	S.S Rod batch: 111585								

D2332-5 Sub 11/4 x4
D2332-7 Sub 11/4 x4
D2332-11 Sub 11/4 x4
D2332-17 Sub 11/4 x4

Sub 11/4
x4

11-02-21

W/O:		WORK ORDER CHANGES					
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Work Order ID 66233

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Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

11-02-22

11/02/22



160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

JUL 2/22



170



Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

0.00

0.00

11-2-22



BTS

11/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 66233

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Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/08/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/11/02/24

0.00

Memo

(24)

190



Packaging

Packaging

Identify as per dwg & Stock Location: 5/2

0.00

0.00

Memo

11/11/24 SK 411

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/02/24 JF

CMF
11-02-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:43:23 AM

Page 1

Work Order ID: 66233

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R.250		Purchased	No			100	f	34.5052	0.1	0.421053			
304 SS Round bar .250													

Location	Loc Qty	Loc Code
MAT	22.947368	
114482 ✓	22.947368	
MAT028	11.557868	
107387	11.557868	

m-l 11/02/10

0.421053

M304TR1.000W.049		Purchased	No			100	f	23.5153	0.43	1.810526			
304 RD Tube 1.00 x .049W													

Location	Loc Qty	Loc Code
MAT018	23.515268	
108756	5.553684	
111457 ✓	17.961584	

m-l 11/02/11

1.810526

M304TR0.500W.035		Purchased	No			110	f	147.5650	1.25	5.263158			
304 RD Tube .500 x .035W													

Location	Loc Qty	Loc Code
MAT	147.5650134	
115593	9.080387	
115990	38.4846264	
116720 ✓	100	

m-l 11/02/10

5.263158

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Picklist Print

February 8, 2011 8:43:24 AM

Page 2

Work Order ID: 66233

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 4.00

Required Qty: 4.00

AN4-4A Purchased No 170 Each 158.0000 1 4
Bolt

Location Loc Qty Loc Code

ST356 157

114615 157

ST361 1

111295 1

AN960JD416L NAS1149D0416J Purchased No 170 Each 110.0000 3 12
Washer

Location Loc Qty Loc Code

ST346 110

110153 110

MS21042L4 Purchased No 170 Each 5,616.000 1 4
Nut

Location Loc Qty Loc Code

ST300 5616

1123143 2

115589 10

115621 21

116188 3500

116548 83

116823 2000

February 8, 2011 8:43:24 AM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

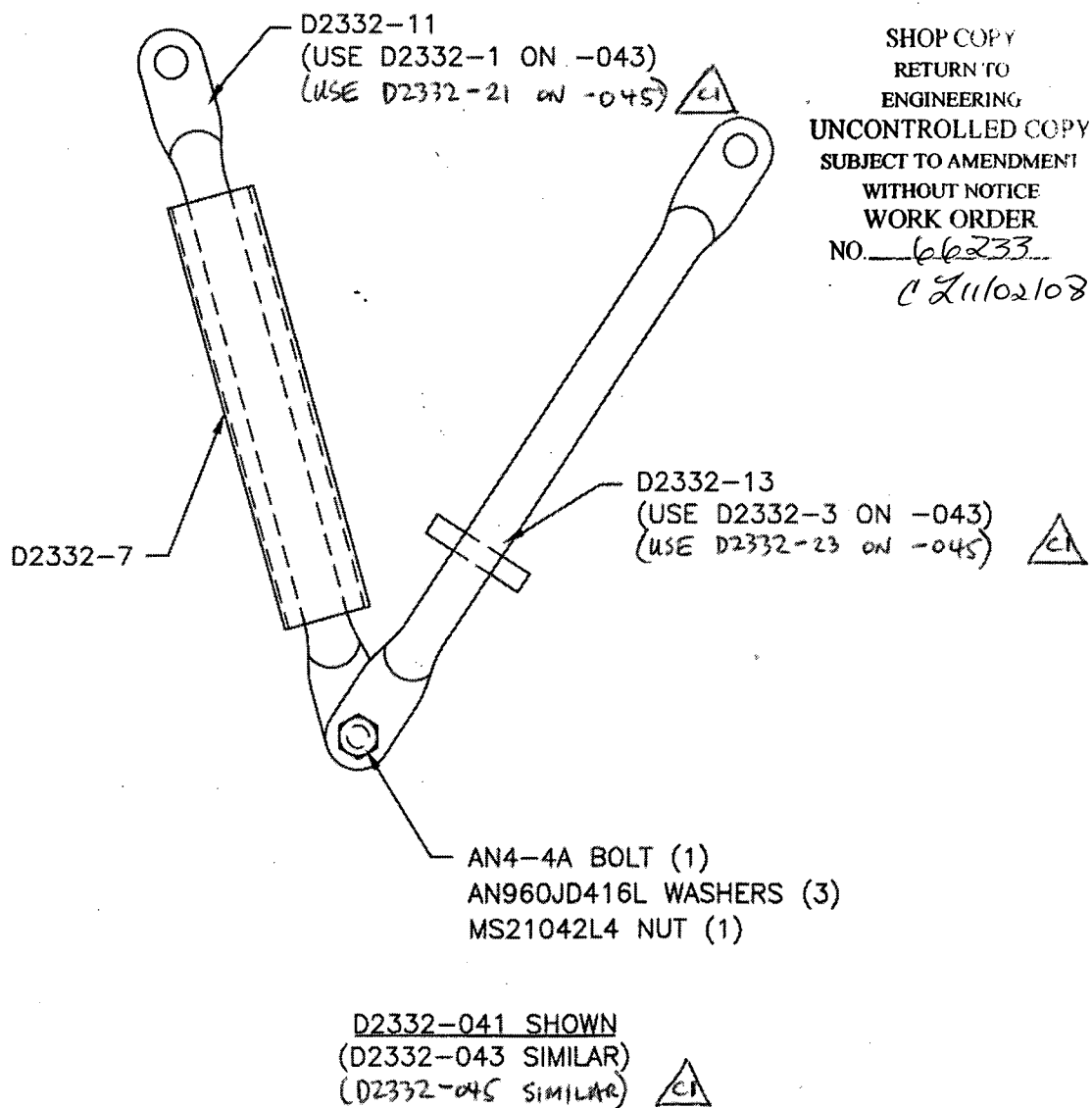
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



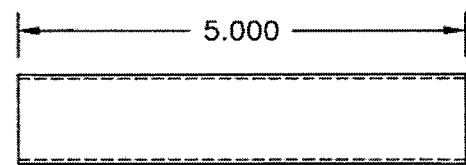
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6.350

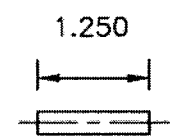


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
	SCALE 1:2	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD)
C1	03.08.06	MAKE -043 PROP 8.00" LONG (VNT)
		ADD -045 PROP 7.25" LONG

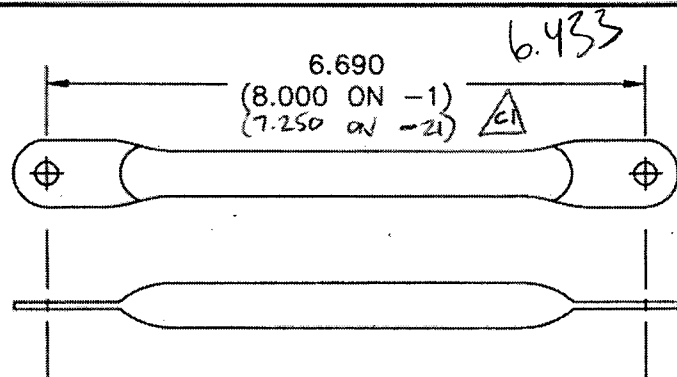


D2332-7 LOCKING COLLAR

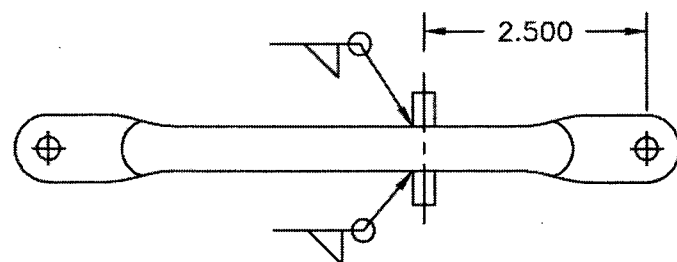
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66.233



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

{D2332-3 SIMILAR - M/F D2332-1 & D2332-5}
{D2332-23 SIMILAR - M/F D2332-21 & D2332-5}



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
R 03.01.04

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